



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

004467

K642-512
Job Sheet 179066



Part No: K642-512

Job Qty: 1 ea

Part Name: Saddles



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/13/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV Q IPP Rev.A 05.06.07 new issue EC IPP Rev.B 05.02.08, Per ECN1080P

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/29/18	0.00	0.00	Start Up Stores/Pkg-2		JUL 18 2018
110	Packaging	1 pcs		6/29/18	0.00	0.00	Packaging1-5		JUL 18 2018
120	QC	1 pcs		6/29/18	0.00	0.00	QC4		JUL 27 2018
125	DC	1 pcs		6/29/18	0.00	0.00	DC		JUL 27 2018
130	Packaging	1 pcs		6/29/18	0.00	0.00	Packaging3-2		JUL 27 2018
140	QC21-SA	1 Ea		6/29/18	0.00	0.00	QC21		JUL 27 2018

Part Op 125 - Create White labels per PPP K642-512 CHG005
Descriptions: 130 - Identify and pack for shipping as per PPP K642-512 Location:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C35A	Bolt	3 Ea (3 ea)	90-Start up Operation	FM135470
AN3C36A	Bolt	9 Ea (9 ea)	90-Start up Operation	FM137074-1
AN3C41A	Bolt	8 Ea (8 ea)	90-Start up Operation	5004930
AN4C6A	Bolt	12 Ea (12 ea)	90-Start up Operation	5027515
AN5C11A	Bolt	8 Ea (8 ea)	90-Start up Operation	5006317
AN5C12A	Bolt	4 Ea (4 ea)	90-Start up Operation	FM129245
AN5C13A	Bolt	4 Ea (4 ea)	90-Start up Operation	FM130466
AN5C15A	Bolt	1 Ea (1 ea)	90-Start up Operation	FM137587-1
AN5C32A	Bolt	2 Ea (2 ea)	90-Start up Operation	5047244
AN5C34A	Bolt	2 Ea (2 ea)	90-Start up Operation	FM132522
AN5C35A	Bolt	1 Ea (1 ea)	90-Start up Operation	FM129871
D206-648-013	Ground Handling Wheel Modification	1 Ea (1 ea)	90-Start up Operation	5059293
D2652	Bushing	16 Ea (16 ea)	90-Start up Operation	505460-7
D2712	Set Screw	10 Ea (10 ea)	90-Start up Operation	5031303
D2932-2	Saddle RH Out, 206	1 Ea (1 ea)	90-Start up Operation	5059232
D2933-2	Saddle RH In, 206	1 Ea (1 ea)	90-Start up Operation	5059233
D2934	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5054584
D2935	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5054582
D2938-2	Saddle RH Out, 206	1 Ea (1 ea)	90-Start up Operation	5059235
D2939-2	Saddle RH In, 206	1 Ea (1 ea)	90-Start up Operation	5059237
D3396-3	Bushings	2 Ea (2 ea)	90-Start up Operation	5149554
D3407-043	Tow Ring	1 Ea (1 ea)	90-Start up Operation	5059286
D3456-1	Washer	1 Ea (1 ea)	90-Start up Operation	5079335

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only



DISPOSITION		AGAINST DEPARTMENT/PROCESS				Work Order update only																																																																																																														
Work Order: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	MRB (QS1042) Approval																																																																																																														
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																																																															
NCR No. _____	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																																																															
Date: _____	Not Approved ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																
 Container No: S093059 Part: K642-512 Job No: 179066 Serial No/Batch: S093059 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/18/18																																																																																																																				
Completed By _____																																																																																																																				
Lead hand / Supervisor Approval Verification _____																																																																																																																				
QC / QA Coordinator Approval _____																																																																																																																				
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OTHER: _____																																																																																																																				

D3457-1	Washer	2 Ea (2 ea)	90-Start up Operation
D3672-1	Washer, Phenolic	24 Ea (24 ea)	90-Start up Operation
D3672-3	Washer, Phenolic	24 Ea (24 ea)	90-Start up Operation
D3672-7	Washer, Phenolic	24 Ea (24 ea)	90-Start up Operation
MS21043-3	Nut	20 Ea (20 ea)	90-Start up Operation
MS21043-4	Nut	13 Ea (13 ea)	90-Start up Operation
MS21043-5	Nut	4 Ea (4 ea)	90-Start up Operation
NAS1149C0332R	Washer	24 Ea (24 ea)	90-Start up Operation
NAS1149C0432R	Washer	24 Ea (24 ea)	90-Start up Operation
NAS1149C0532R	Washer	8 Ea (8 ea)	90-Start up Operation

5035433
 F1163255
 5057022
 F157442
 5062620
 5062296
 5024470
 5049837
 5050052
 5055951

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C35A	3	68	0
	AN3C36A	9	550	0
	AN3C41A	8	472	0
	AN4C6A	12	401	0
	AN5C11A	8	82	0
	AN5C12A	4	43	0
	AN5C13A	4	47	0
	AN5C15A	1	28	0
	AN5C32A	2	66	0
	AN5C34A	2	133	0
	AN5C35A	1	62	0
	D206-648-013	1	5	0
	D2652	16	469	0
	D2712	10	719	0
	D2932-2	1	3	0
	D2933-2	1	5	0
	D2934	2	70	0
	D2935	2	52	0
	D2938-2	1	4	0
	D2939-2	1	3	0
	D3396-3	2	46	0
	D3407-043	1	23	0
	D3456-1	1	320	0
	D3457-1	2	27	0
	D3672-1	24	1,078	0
	D3672-3	24	1,259	0
	D3672-7	24	681	0
	MS21043-3	20	853	0
	MS21043-4	13	721	0
	MS21043-5	4	93	0
	NAS1149C0332R	24	5,783	0
	NAS1149C0432R	24	2,063	0
	NAS1149C0532R	8	283	0

Part Specifications

Specifications could not be found.

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -557	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80							1	1		D4368-041	FWD WEARPLATE ASSY
81							1	1		D4368-043	AFT WEARPLATE ASSY
82A							1	1		D4383-1	WEARPAD
82B							1	1		D4383-3	WEARPAD
83							20	20		D3873-3	BUSHING
84								24		D3411-3	WASHER
85							2			D3275-1	SPACER
86A							6	6		AN3C40A	BOLT
86B							2	2		AN3C37A	BOLT
86C							2	2		AN3C36A	BOLT
87							10	10		MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE
 (2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

REFERENCE ONLY

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Revision: Q

Date: 13.08.12

4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -557	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-557	WEARSHOE KIT (REPLACES -547 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		AN3C4A	* BOLT ⁽¹⁾
5A					2			2		NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C516L)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C6A	BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1				D4956-15	* WEARSHOE ⁽¹⁾ (REPLACES D3535-15 + D3536-15)
23A					1	1				D4956-23	* WEARSHOE ⁽¹⁾ (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-39	* WEARSHOE ⁽¹⁾ (REPLACES D3535-39 + D3536-39)
25A					1	1				D4956-35	* WEARSHOE ⁽¹⁾ (REPLACES D3535-35 + D3536-35)
26A			8	8	78	78	8			AN3C4A	* BOLT ⁽¹⁾
26B			8	8	78	78	8			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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Revision: Q

Date: 13.08.12

Kim Johnston

From: Sonia Quirion
Sent: Wednesday, July 18, 2018 2:23 PM
To: Kim Johnston
Subject: l/b

D350-607-541 S093363 S093364 red and white
D350-607-545 S093365 S093367 red and white
d350-589-011 s093336 x2
d130-727-111 s093101 x2
k642-512 s093059 x1

Change Record

PAGE 1 OF 1

Part Number: D206-642-511/-512 (K642-511/-512 SADDLE KITS, INTERNAL)

Description: FLOAT SKIDTUBE , LH/RH

[illegible]